

**Work Order ID 74039**

Tuesday, September 20, 2011 4:06:09 PM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Item Name: Rear Locker Extender

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:     Date: 11-09-20Tooling:     Date:     

Run Start

QC:     Date:     SPC (Y/N):     Date:     

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

nl 11-11-02 (1)

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14968  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 118800H 11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74039**

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Page 2

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00							
	Memo	0.00							
	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Check hole locations to template. DT 8824 Check process sheet and audit.								
140  Packaging	Pick Kit	0.00							
	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74039**

Tuesday, September 20, 2011 4:06:09 PM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00				<u>11</u>	<u>11</u>	<u>11</u>	<u>02</u> ①
160  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D350-604-041 Location: _____ PPP Rev: _____	0.00  0.00							<u>11/11/11</u> ②
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>11/11/11</u> ③ MF 11-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 4:06:14 PM

Page 1

Work Order ID: 74039

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender



Start Date: 9/20/2011

Required Date: 9/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2600-6		Purchased	No			110	Each	303.0000	4				
--------	--	-----------	----	--	--	-----	------	----------	---	--	--	--	--



Camlock Stud

Location

Loc Qty

Loc Code

ST380

303

118611

1

118752

16

118800

196

118852

90

D350-604-041P		Purchased	No			120	Each	0.0000	1	1			
---------------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--



Rear Locker Extender

D2268		Manufactured	No			140	Each	15.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Decal

Location

Loc Qty

Loc Code

ST010

15

69592

5

72054

10

D2269		Manufactured	No			140	Each	12.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Decal

Location

Loc Qty

Loc Code

ST010

12

67421

2

72055

10

4

4

1

1

1

11/1/01

1

74039

9/21/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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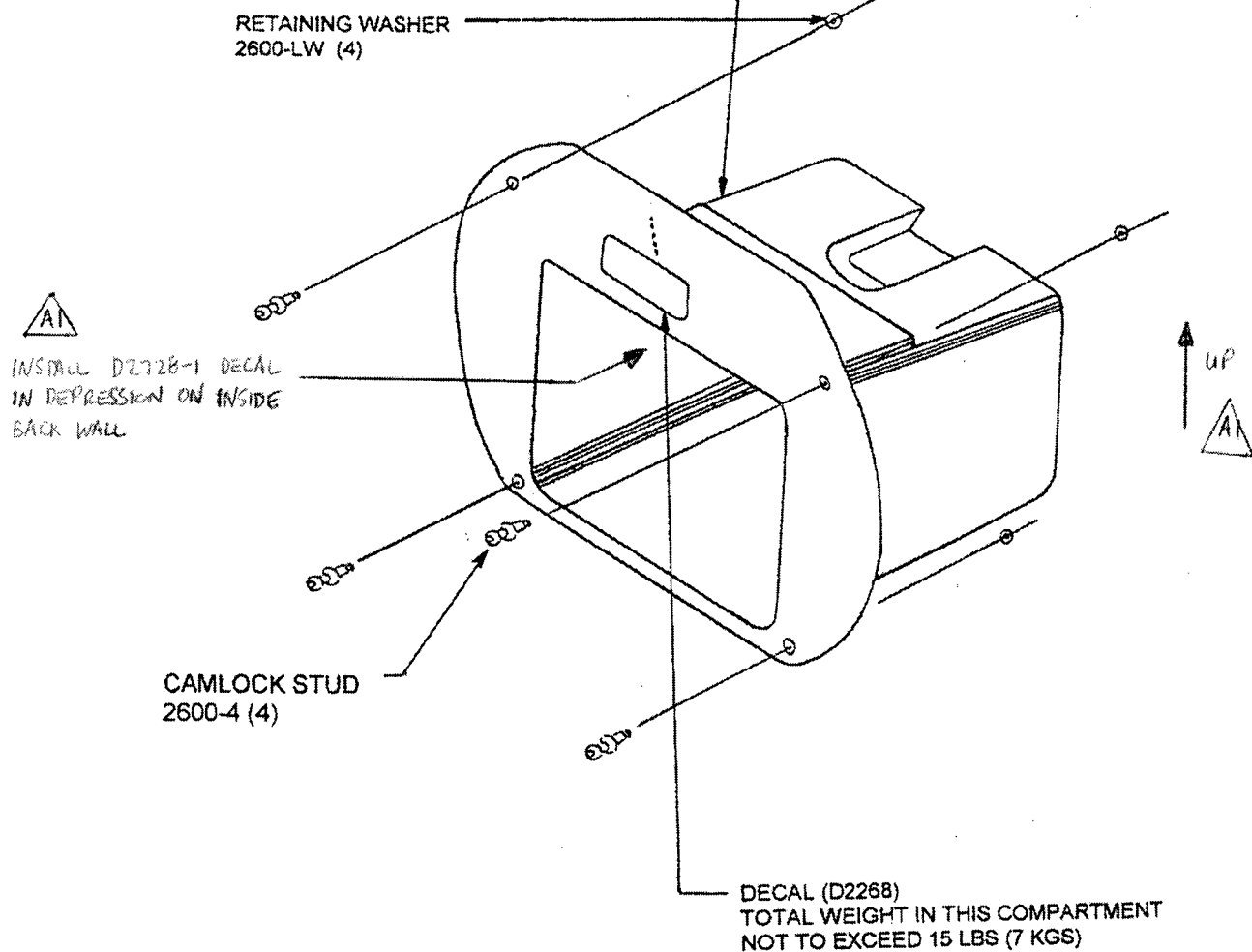
**NOTE:** Date & initial all entries





DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
AI	02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE	

RELEASED  
02.04.03



### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	40911
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/10/2011	21/09/2011	18754	Brigitte Golden		PO14968		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B74040 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div><div><u>No. série</u></div><div><u>No. lot</u></div><div>B74040</div><div>36517</div></div>			
1	0	1	DKC134-0003	Line #4 Rear Locker Extender D350-604-041P B74039 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div><div><u>No. série</u></div><div><u>No. lot</u></div><div>B74039</div><div>36518</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department



AQ-357

Dr : Vendredi, 2011-10-14 15:59:54  
 Utilisateur: Pascal Carignan

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD	Nom Dessin : REAR LOCKER EXTENDER
Numéro Job : 36518	Numéro Article : DKC134-0003
Numéro Soumission : 3482	Numéro Dessin : D350-604-041 & D2273
Numéro B.A. : Kit 860	Projet Numéro : DK-362
Cette fois : 2011-10-14 No. B.V. :	Révision dessin : A & D
Prsht Rev. : NC	Matériel : Derakane 470-36/411/510
Prem. fois : - - Type :	Date Dûe : 2011-10-21 Qté: 1 Udm: UNITE
Job précédente : 36517	

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
 N° de pièce Assemblage Dart Aerospace: D350-604-041

B 74039

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: Sceau:

2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

 Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)  
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-32675-1

3.0 AMB0286 Catalyst N° DDM-9

 Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)  
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747 Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 21-10-11 Sceau:



Date: Vendredi, 2011-10-14 15:59:54  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 36518

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003 .

Date: 24-10-11 Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 24-10-11 Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-32577-2

9.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-31000-2

11.0

AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot:

1-28778-1

12.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 32% Température: 72°F Heure: 3:15

Quantité: 1 Date: 24/10/11 Sceau: S.V A.M

Date: Vendredi, 2011-10-14 15:59:54

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 36518

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

13.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: \_\_\_\_\_

14.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: \_\_\_\_\_

15.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: \_\_\_\_\_

Date: \_\_\_\_\_

Sceau: \_\_\_\_\_

16.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1

Date: 25/10/11

Sceau: \_\_\_\_\_



17.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 25-10-11

Sceau: \_\_\_\_\_



18.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30270-1

19.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

Date: Vendredi, 2011-10-14 15:59:55

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 36518

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

20.0


PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 26 oct 11 Sceau:  N° fiche de Mélange: N/A

21.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-32365-1

22.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6697-1

23.0

ASSEMBLAGE

Assemblage mécanique




Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 27-10-11 Sceau: 

24.0

IDENTIFICATION

Identification à encre indélébile




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 36518

N° de Fabrication: 27/10/11

Quantité: 1 Date: 27/10/11 Sceau: 

25.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Vendredi, 2011-10-14 15:59:55  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 36518

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 27-10-11

Sceau:



26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date: 27 oct 11

Sceau:



fab 27 oct 2011  
Job 36518